

Date: Tuesday, 10/06/2008 12:54:39 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: INNER AFT SADDLE		
Job Number	: 39796			Part Number	: D5957		
Estimate Number	: 11082			Drawing Number	: D5957 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 10/06/2008 S.O. No. :			Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : MACHINED PARTS			Due Date	: 30/06/2008 Qty: 12		
Previous Run	: 39621			Um:	Each		
Written By	:			Comment	: Est Rev:E Re-Format 05-11-29 JLM Est Rev:F ecn826 06.12.06 ec		
Checked & Approved By	: JUL 08-6-10						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101007	<p>Mat not in computer <small>Saddle Billet</small> 8/08/06</p> <p>Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s) D6101-007(7075-T7351) Size 2.50" x 7.50" X 8.25" (Grain along 7.50") Batch: B34825</p> <p>8/08/06 (12)</p>
2.0	HAAS3	<p>HAAS CNC VERTICAL MACHINING #3</p> <p>Comment: HAAS CNC VERTICAL MACHINING #3</p> <p>1-Machine as per folio D5957, Ensure Batch Number is entered</p> <p>2-Machine Keyway</p> <p>3-Deburr & Tumble</p> <p>8/08/06 (12)</p>
3.0	QC1	<p>INSPECT ALL DIM TO DIM SHEET</p> <p>Comment: INSPECT ALL DIM TO DIM SHEET</p> <p>8/08/07 (12)</p>
4.0	QC8	<p>SECOND CHECK</p> <p>Comment: SECOND CHECK</p> <p>8/08/11 (12)</p>
5.0	HAND FINISHING1	<p>HAND FINISHING RESOURCE #1</p> <p>Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1</p> <p>8/08/11 (12)</p>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D5957 PAR #: N/A Fault Category: Prod / Machined Part NCR: Yes No DQA: D Date: 08/08/12
 QA: N/C Closed: D Date: 08/08/12

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/06	2.0	operator Joger Machine in .100" instead of .001" increment The cutter Plunged in the part. (operator error) <u>MM</u>	08/08/06	Scrap and Destroy and Replace. Qty 40 B# 34875 & Remind operator to be more cautious.	8/08/06	8/08/06	<u>MM</u>	08/08/06
			08/08/06	Fix Program so adjustment doesn't have to be done by hand.	10/08/06	8/08/06		08/08/06
				Par 08-024		8/08/06		

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 12:54:39 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER AFT SADDLE

Job Number: 39796

Part Number: D5957

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M108523



12x

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 11:15

OVEN TEMPERATURE: 220

FINISH TIME: 11:45

01
S

M-F 08/08/11

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-11

218

8.0 PACKAGING 1

PACKAGING RESOURCE #1



12x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 621

8/8/11

SP

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



M-F 08-08-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD			Work Order: 39796
Description: Inner Aft Saddle		Part Number:	D5957
Inspection Dwg: D5957	Rev: B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		440	440	440	440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		320	320	320	320		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.316	322	318	318	318	318		
L	0.495	0.505		500	500	500	500		
M	0.490	0.510		500	500	500	500		
N	1.865	1.885		1.876	1.871	1.875	1.874		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.260	2.260	2.260	2.260		
Q	0.307	0.312		310	309	309	309		
R	0.760	0.765		760	760	760	761		
S	0.490	0.510		501	510	505	506		
T	1.625	1.645		1.636	1.635	1.635	1.635		
U	2.000	2.020		2.002	2.003	2.003	2.003		
V	0.023	0.043		023	033	033	033		
W									
X									
Y									
Z				2					
AA				5					
AB				2					
AC				U					
AD				V					
AE									
AF									
Accept/Reject									

Measured by:	81	/	Onk	Audited by:	J.F.
Date:	08/08/06	/	08/08/07	Date:	08/08/11

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	DD

DART AEROSPACE LTD		Work Order:	397910
Description: Inner Aft Saddle		Part Number:	D5957
Inspection Dwg: D5957	Rev: B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	4X	5X	6X	7X	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.248		
F	4.745	4.755		4.750	4.750	4.750	4.748		
G	0.315	0.322		.320	.320	.320	.322		
H	1.522	1.532		1.530	1.530	1.530	1.526		
I	3.048	3.058		3.050	3.050	3.050	3.057		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.313	0.318	322	.318	.318	.318	.322		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.500	.500	.500	.500		
N	1.865	1.885		1.875	1.877	1.877	1.881		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.240	2.240	2.240	2.240		
Q	0.307	0.312		.309	.309	.309	.309		
R	0.760	0.765		.760	.760	.760	.762		
S	0.490	0.510		.502	.502	.503	.502		
T	1.625	1.645		1.637	1.637	1.637	1.639		
U	2.000	2.020		2.000	2.000	2.002	2.004		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	8/5	/	7/11	Audited by:	JF
Date:	08/08/08	/	08/08/08	Date:	08/08/11

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	AS

DART AEROSPACE LTD

Work Order: 39796

Description: Inner Aft Saddle

Part Number: D5957

Inspection Dwg: D5957

Rev: B

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	18	19	20	21	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.749	1.749	1.748		
C	5.245	5.255		5.250	5.249	5.249	5.248		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.247	5.248	5.248	5.249		
F	4.745	4.755		4.747	4.748	4.748	4.749		
G	0.315	0.322		.322	.322	.322	.322		
H	1.522	1.532		1.525	1.525	1.526	1.526		
I	3.048	3.058		3.052	3.052	3.054	3.052		
J	4.575	4.585		4.581	4.581	4.580	4.579		
K	0.313	0.318	322	-322	.322	.322	.322		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.495	.495	.495	.496		
N	1.865	1.885		1.849	1.879	1.878	1.878		
O	7.990	8.010		8.006	8.000	8.000	8.000		
P	2.240	2.260		2.259	2.258	2.254	2.255		
Q	0.307	0.312		.309	.309	.309	.309		
R	0.760	0.765		.761	.761	.761	.761		
S	0.490	0.510		.502	.502	.503	.502		
T	1.625	1.645		1.637	1.637	1.636	1.637		
U	2.000	2.020		2.002	2.002	2.001	2.001		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: *JM*
 Date: 08/08/07

Audited by: *JF*
 Date: 08/08/11

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	

ART AEROSPACE LTD

Work Order: 39796

Description: Inner Aft Saddle

Part Number: D5957

Inspection Dwg: D5957

Rev: B

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

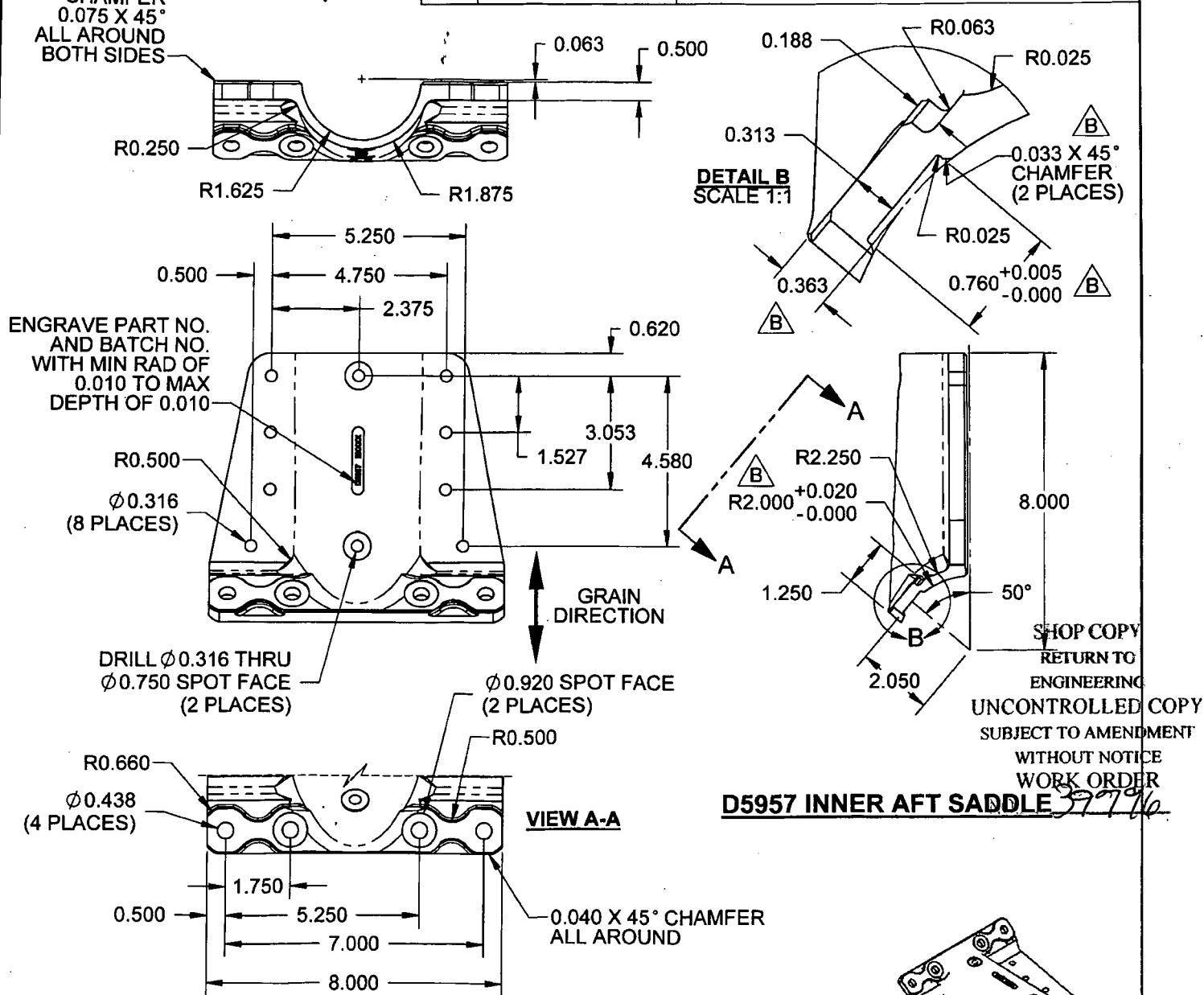
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	$\times 12$	\odot	\square	f	By	Date
A	0.438	0.443		.440					
B	1.745	1.755		1.750					
C	5.245	5.255		5.250					
D	6.995	7.005		7.000					
E	5.240	5.260		5.251					
F	4.745	4.755		4.751					
G	0.315	0.322		.322					
H	1.522	1.532		1.526					
I	3.048	3.058		3.053					
J	4.575	4.585		4.580					
K	0.313	0.318		.322					
L	0.495	0.505		.500					
M	0.490	0.510		.496					
N	1.865	1.885		1.880					
O	7.990	8.010		8.006					
P	2.240	2.260		2.255					
Q	0.307	0.312		.309					
R	0.760	0.765		.760					
S	0.490	0.510		.502					
T	1.625	1.645		1.636					
U	2.000	2.020		2.002					
V	0.023	0.043		.033					
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: *cmz*
Date: 08/08/07Audited by: *J.F.*
Date: 08/08/14

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	



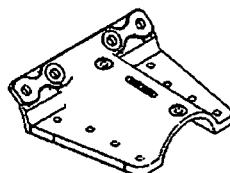
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED #	DRAWING NO. D5957	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE INNER AFT SADDLE		SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; ϕ 0.316 WAS ϕ 0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	



NOTES:

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3 
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020



ISOMETRIC VIEW
SCALE 1:8